Dart Aerospace Ltd. Monday, 11/6/2006 2:40:04 PM Kim Johnston User **Process Sheet** : SADDLE SPACÈR : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer : 29345 **Job Number Estimate Number** : 11062 : D2934 :NIA **Part Number** P.O. Number S.O. No. : NIA . D2934 REV B : 11/6/2006 **Drawing Number** This Issue : N/A Project Number Prsht Rev. · NA : SMALL /MED FAB **Drawing Revision** Type First Issue : 28920 Material **Previous Run** Each : 11/20/2006 Qty: 40 Um: **Due Date** Written By Checked & Approved By Comment Est Rev:B Now 6061-T6 06-06-23 JLM **Additional Product** Job Number: **Machine Or Operation:** Description: Seq. #: 1.0 M6061T6S080 6061-T6 .080 Sheet 1.3356 sf(s) Comment: Qty.: 0.0334 sf(s)/Unit Total: Material: 6061-T6 0.080" Thick Batch M101178 021109 FLOW WATER JET 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2934 M 66 11 09 Dwg Rev: B Prog Rev: B CG-11-09.

INSPECT PARTS AS THEY COME OFF MACHINE 2-Deburr if necessary 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK HAND FINISHING RESOURCE #1 5.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1

Page 1

Form: rprocess

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
<b>i</b>									
•				=					
Part No	);	PAR #: Fault Category: No	CR: Ye	s No DQ	A: <u>=</u>	Date: 💆	6/11/16		
				N/C Closed					

ŅCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Varification						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
İ											

NOTE: Date & initial all entries

Monday, 11/6/2006 2:40:05 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: SADDLE SPACER Customer: CU-DAR001 Dart Helicopters Services Part Number: D2934 Job Number: 29345 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1

PACKAGING 1 7.0

QC21

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:\_

57350

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

8.0



Part Ae	rospace	Ltd							
W/O:			WC	RK ORDER CHANGES	3				
			NGE	Ву	Date	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Categ	jory: l					
NCR:		V	WORK ORDE	R NON-CONFORMAN			a:	Date:	
DATE	STEP	<b>Description of NC</b> Section A	Initial Chief Eng	Corrective Action Section E Action Description Chief Eng	Sign &		cation ion e	Date:	Approval QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29345
Description: Saddle Spacer	Part Number:	D2934
Inspection Dwg: D2934 Rev: B		Page 1 of 1

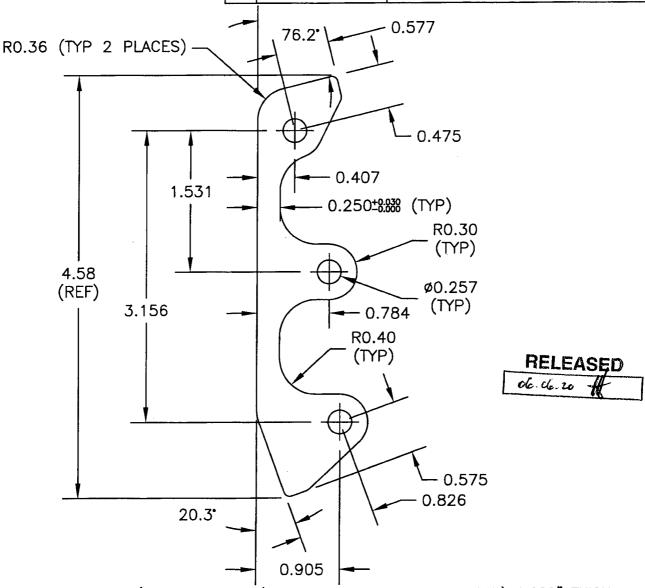
Inspection Dwg	: D2934 <b>Rev</b>	; В					age i oi i
	FIRS.	T ARTICLE I	NSPECTI	ON CHI	ECKLIST		
	Х	First Arti	cle	Prot	otype		
Drawing	Talamana	Actual	Accept	Reject	Method o		mments
Dimension	Tolerance	Dimension	Accept	Reject	Inspectio	n	
0.475	+/-0.010	0.477			VEIN		
0.407	+/-0.010	0.407	J		VerN		
0.250	+0.030/-0.000	0.265			VerN		
R0.30	+/-0.030	RO.30	<b>!</b>		Radius (	TURGE	
Ø0.257	+0.005/-0.000	0.257	<i>J</i>		vern		
0.784	+/-0.010	0.784	V		VerN		
0.826	+/-0.010	0.826			vern		
R0.36	+/-0.030	RO.36	V		RADIUS C	TUAGE	
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Measured by:	M. M/	Audited by:			Prototype	N/A	
Date: 0	6 11 09	Date:	06/11/	09		Date:	N/A
Rev Date	Change					Revised by	Approved
A 04.08.12	New Issue					KJ/JLM	1

Rev	Date	Change	Revised by	Approved
Α	04.08.12	New Issue	KJ/JLM	1
В	06.06.23	Dwg Rev. changed	KJ/JLM 💉	



DRAWN BY DART AEROSPACE USA, INC. 77 PORT HADLOCK, WA REV. B CHECKED APPROVED DRAWING NO. D2934 SHEET 1 OF 1 TITLE SCALE DATE SADDLE SPACER 06.05.29 1:1 **NEW ISSUE** Α 99.11.02

ADD 6061-T6 MATERIAL



06.05.29

В

1) MATERIAL:

NOTES:

6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)

**RETURN TO** 

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICKNOWN CONTROLLED COPY

(REF DART SPEC M5052H32S.080) 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

SUBJECT TO AMENDMENT WITHOUT NOTICE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

WORK ORDER

5) ALL DIMENSIONS ARE IN INCHES

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